RZAN

V	ork	Order	ID	100247
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\*100247\*

Page 1

April-22-13 12:.	51:47 PM										
Revision ID:	D2237 Striker Plate		A	Accept	*N900	040	100	<b>)*</b> s	Setup Star	IV	S1* S2*
	4/22/13	<b>Start Qty: 20.00</b>	*20*	, is	Cust Item 1	ID:	•				
Required Date: Reference:	5/03/13	<b>Req'd Qty:</b> 20.00	*20*		Customer:						
Approvals:	Process Plan	:_ML5	Date: 13-04-24	Tooling:	D	ate:		. <b>R</b>	Run Star	171	R1*
			·	SPC (Y/N): _	D	ate:			Stoj	` *N	R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D2237	Rev 1	D1									
*100 *100* Waterjet		FLOW WATER JET	`	0.00				_20	0		Jm13-6-
FLOW CNC Waterjo	et	Memo 1-Cut as per if necessary		0.00 Prog Rev: <b></b> 2-D	евит						
110		QC2- Inspect parts off m	nachine FAI/FAIB	0.00							
*110* QC Quality Control		Мето		0.00				20	0		Jm13-6-4
				۸.0							
120		QC8- Inspect parts - seco	ond check	0.00				$\mathcal{C}$			
*120* QC Quality Control		Memo		0.00/36\$				40			

NCR: Yes / No
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DQA: \_\_\_\_\_ Date: \_\_\_\_

NCR: Ye	es / No				WORK ORDER NON-	-CON	iFORN	MANCE / UPI	DATE	QA Closed:	Date	:	
Work Order	<del>·</del>	<u> </u>			DISPOSITION				AGAINST DI	DEPARTMENT/PROCESS			
Part No					Rework Scrap		<b></b>		Crosstube Small Fab	Water Jet Prod. Eng. Coor.		Engineering Quality	
NCR N	0				Use-as-is Work Order Update		Thermoforming Finishin Large Fab Composit			Rec/Sto	Other		
Root					iption of work order update	- 1	nitial		tion	Sign &	V = 'S' = A'	061	
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desci	ription	Date	Verification	QC Inspector	
Ooc/Data quip/Tooling	╣ .												
Operator	-					•							
Material	-											į	
etup	-	ŀ											
Other	-												
rocess						1							
Supplier				•			İ	,				·	
raining	7												
Jnapproved							•						
						FAUL	T CATE	GORY					
Landin	g Gear			_	General	_	ı		_	7	<b>-</b>	¬ · ·	
L	Bending				Bend	Ш	Grain		į_	Ovalized		Pressure/Forced	
	Centre N	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa			Over/Under	F	Temperature/Cure	
	Cracks			<u> </u>	Broken/Damaged			on Incomplete	<u>  -</u>	Part Incorre	<u> </u>	Weld	
	Crushed/	'Crimped		<u>_</u>	Burrs	—		ions incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination	<u> </u>	Maintenance		_	Part Moved			
	Heat Trea				Countersink	Mislabeled			<u> </u>	Positioned V		¬	
1	Inspection	-	Tube	-	Cut Too Short	-	Misread	<b>i</b>	L	Power Loss/	Surge	Other	
	Ripples in			.	Drill Holes	<b>—</b>	Offset	- 44				·	
1	Torque V			n	Drawing		1	Calibration		· · · · · · · · · · · · · · · · · · ·			
L	Turning S				Finish	-	4	Sequence					
	Wave/Twist in Tube Folio				Outside	Dimensions							

Packaging

NCR:	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
		···········				p.:-					QA Closed:	Date:	
Work Orde	er: _				<del></del>	<b>DISPOSITION</b> Rework	1	:	Skid-tube	AGAINST DE	PARTMENT,	/PROCESS  Water Jet	Engineering
Part No.  NCR No.				Scrap Use-as-is Work Order Update			Machining noforming Large Fab	Small Fab Finishing Composite	4	d. Eng. Coor. re/Packaging Supplier	Quality Other		
Root					Descri	ption of work order update	1	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					`								
						<del></del>	AUL	T CATE	GORY				
Landi	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	-	Instruct Mainte Mislabe Misread Offset Out of 0	ion Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		0247		*100		Page 3					
Revision ID: Item Name:	D2237 Striker Plate 4/22/13 5/03/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*	Accept	*N900040100  Cust Item ID:  Customer:		)* <sup>s</sup>	etup Sta	171	S1* S2*	
Reference: Approvals:		n:	Date:	Tooling: SPC (Y/N):		nte:	-	R	tun Sta Sto	on '' IN	R1* R2*
Sequence ID/ Work Center II  160 *160* QC	)	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Quality Control		Memo		0.00					,	m.	= 3-6-04

											DQA.		s	
NCR:	⁄es	/ No				WORK ORDER NON-C	O	NFOR	MANCE / UPDATE		QA Closed:	Date	<u>a:</u>	
						DISPOSITION			AGAINST	DEPARTMENT/PROCESS				
Part No				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite				Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other			
Root			<u> </u>		Descri	Lption of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspect	or
Doc/Data						<del></del>								
Equip/Tooling			ļ				ļ							
Operator														
Material	П													
Setup					1							·		
Other							1							
Process	П													
Supplier														
Training									·					
Unapproved			]											
		:				F	AUL	T CATE	GORY			<del></del>		
Landi	ng G	Gear				General		-		_	,	-		
		Bending				Bend	L	Grain		L	Ovalized		Pressure/Forced	I
Centre Not Concentric to O/S				o/s	BOM/Route	L	Hardwa	re	L	Over/Under	tolerance	Temperature/Cu	ıre	
Cracks			Broken/Damaged		Inspect	on Incomplete	_	Part Incorred	ct _	Weld				
	Crushed/Crimped				Burrs		Instruct	ions Incomplete/Unclear	L	Part Lost/Mi	ssing	Wrong Stock Pul	led	
		Cuffs				Contamination		Mainte	nance		Part Moved			
	Heat Treat Countersink					Mislahe	led		Positioned V	Vrong				

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-22-13 12:51:47 PM

Work Order ID:

100247

Parent Item:

D2237

Parent Item Name:

Striker Plate

**Start Date:** 4/22/13

Required Date: 5/03/13

**Start Qty: 20.00** 

Required Qty: 20.00

Comments:

IPP C02.05.11Clarify IPPNG

IPP D 06.05.25 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	182.1100	0.01	0.210526	-		Jm13-6-1
304/316 .032 Sheet				Location		Loc Oty	Lo	c Code				···	<del></del>
				Location			1,0	c Code					
				MAT020		182.11							
	•			118	271	10.76							
				120	866	55.6							
				121	889	115.75			121	897			



NCR:	Yes	/	No

DQA: \_\_\_\_ Date: \_\_

NCR: Ye	es / No				WORK ORDER NON-	CONF	ORN	MANCE / UP	DAIE	QA Closed:	Date:			
Work Order					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No					Rework Scrap		Skid-tube Crosstube Machining Small Fab		Small Fab	Water Jet Prod. Eng. Coor.		Engineering Quality		
NCR No	D				Use-as-is Work Order Update	- - -		oforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other		
Root				Descr	iption of work order update	Init	ial	Act	tion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Desci	ription	Date	Verification	QC Inspector		
oc/Data														
quip/Tooling						,								
perator														
//aterial		1												
etup		· ·												
Other							l		•'					
rocess		1					.		•					
upplier														
raining														
Inapproved			<u> </u>	<u> </u>										
					<del></del>	AULT (	CATE	GORY			<del> </del>			
Landin	g Gear				General					7	_	<b>.</b> .		
	Bending				Bend	-	rain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced		
_	Centre N	ot Conce	ntric to	o/s	BOM/Route	_	ardwar		<u> </u>	Over/Under	tolerance	Temperature/Cure		
Ĺ	Cracks				Broken/Damaged	$\vdash$		on Incomplete		Part Incorred	<b>⊢</b>	Weld		
L	Crushed/	'Crimped		_	Burrs	ln:	Instructions Incomplete/Unclear		Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
	Cuffs				Contamination	Шм	Maintenance		_	Part Moved				
	Heat Trea	at		L	Countersink	Шм	Mislabeled			Positioned V		<b>,</b>		
. [	Inspectio	n Strip in	Tube		Cut Too Short	М	Misread			Power Loss/	Surge	Other		
	Ripples in	n Bend			Drill Holes	$\vdash$	Offset							
	Torque V	Vaves in I	Extrusio	n [	Drawing	Out of Calibration		•						
	Turning S	Sequence			Finish		Out of Sequence							
	Wave/Tv	vist in Tul	be		Folio	0	utside	Dimensions						

DART AEROSPACE LTD	Work Order:	100247
Description: Striker Plate	Part Number:	D2237
January D. D. D. D. D.		<u> </u>
Inspection Dwg: D2237 Rev: D1		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	+/-0.010	0.303"	_		V.	JLM01
0.250	+/-0.010	0.253"	_		V	
1.550	+/-0.010	1.552"	_		J	
1.800	+/-0.010	1.790"	~		V	
0.750	+/-0.010	0.752"	_		ָט <sub>ַ</sub>	
Ø0.128	+0.005/-0.001	0.128"	-		V	
0.034	+/-0.010	0.039	<b>-</b> ,		J.	
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QF is				-		
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Measured by: $\mathcal{J}_{\mathcal{M}}$	Audited by:		Prototype Approval:	N/A
Date: /3-6-4	Date:	13 G Y	Date:	N/A

i	Rev	Date	Change	Revised by.	Approved
-[	Α	07.05.31	New Issue	Revised by KJ/JLM	ad
1			······································	 · · · · · · · · · · · · · · · · · · ·	<del></del>





SHEET 1 OF 1 SCALE 94:10:25 STRIKER PLATE 莊 04.06.15 UPDATE DIMENSION RELEASED 0.180 + 0.010 0.435-0.300 (REF) R0.032 BEND DETAIL Ø0.128 (2) -0.7500.300-0.000-0.000 FLAT LAYOUT MATERIAL: 304/316 SS, 0.034 THICK